

* Reprint *



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

C45-11-1
Job Sheet 191771



Part No: C45-11-1

Job Qty: 10 pcs

Part Name: Sideplate, Solenoid Side



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/8/19

Job Tracking No:

Due Date: 4/30/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG C45-11-1 REV 12 IPP REV A 18.02.14 NEW ISSUE FK VERIFY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	10 pcs	4/30/19	4/30/19	0.00	1.67	Bandsaw - 1		J.C.L.
120	HAAS 4 Axis - B4B NV5000 - 1 B4B	10 pcs	4/30/19	4/30/19	2.00	10.00	HAAS - 1 - B4B HAAS - 2 - B4B HAAS - 3 - B4B HAAS - 4 - B4B		PT 17-03-27 J.C.L.
130	QC 2	10 pcs	4/30/19	4/30/19	0.00	0.00	QC 2 - 1		PT 17-03-27
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		J.C.L. 19-03-29
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 54		
							QC 2 - 56		



Container No: S164685



Part: C45-11-1

Job No: 191771

Serial No/Batch: S164685

Revision: 12

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 03/21/19

				QC 2 - 57				
				QC 2 - 62				
				QC 2 - 63				
				QC 2 - 8				
				QC 2 - 66				
				QC 2 - 64				
				QC 2 - 65				
140	QC 8	10 pcs	4/30/19	0.00	0.00	QC 8 - 12	m/19/04/14	
						QC 8 - 14		
						QC 8 - 17		
						QC 8 - 20		
						QC 8 - 25		
						QC 8 - 3		
						QC 8 - 32		
						QC 8 - 33		
						QC 8 - 35		
						QC 8 - 39		
						QC 8 - 4		
						QC 8 - 44		
						QC 8 - 45		
						QC 8 - 49		
						QC 8 - 58		
						QC 8 - 8		
						QC 8 - 9		
						QC 8 - 68		
						QC 8 - 67		
						QC 8 - 1 (A)		
						QC 8 - 47		
						QC 8 - 40		
150	Outsource - 4 - Anodize	10 pcs	4/30/19	0.00	0.00		04/15/2019	
160	Packaging 2-1 - Receive - B4B	10 pcs DP	4/30/19	0.00	0.00	Packaging 2 - 1 - B4B		
						Packaging 2 - 2 - B4B		
						Packaging 2 - 3 - B4B		
						Packaging 2 - 5 - B4B		
						Packaging 2 - 4 - B4B		
						Packaging 2 - 6 - B4B		
						Packaging 2 - 7 - B4B		
						Packaging 2 - 8 - B4B		
						Packaging 2 - 9 - B4B		
						Packaging 2 - 10 - B4B		
						Packaging 2 - 11 - B4B		
						Packaging 2 - 12 - B4B		
						Packaging 2 - 13 - B4B	DP APR 22 2019	
						Packaging 2 - 14 - B4B		
						Packaging 2 - 15 - B4B		
						Packaging 2 - 16 - B4B		
						Packaging 2 - 17 - B4B		
						Packaging 2 - 18 - B4B		
						Packaging 2 - 19 - B4B		
							Packaging 2 - 20 -	
				Plex 3/20/19 6:10 PM dart.charest-lacombe.julien				

					B4B	
					Packaging 2 - 21 - B4B	
					Packaging 2 - 22 - B4B	
					Packaging 2 - 23 - B4B	
					Packaging 2 - 24 - B4B	
					Packaging 2 - 25 - B4B	
					Packaging 2 - 26 - B4B	
					Packaging 2 - 27 - B4B	
					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
170	QC 6	10 pcs	4/30/19	0.00 0.00	QC 6 - 42	
					QC 6 - 9	
					QC 6 - 68	DAS APR 23 2019 68
					QC 6 - 61	9-89
180	Packaging 3-1 - Stock - B4B	10 pcs	4/30/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	DAS 28
					Packaging 3 - 6 - B4B	9-89
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
						Plex 3/20/19 6:10 PM dart.charest-lacombe.julier

				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
190	QC 21 - SA	10 pcs	4/30/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53

DAS
21
9-30

APR 24 2019

Part Op **100** - (Bandsaw) 1- Cut 9.325" long
 Descriptions: **120** - HAAS1-1 (HAAS CNC Vertical Machine) 1-Machine as per folio **FC 712** - FOLIO REV: **AA** DWG
 REV: **12** 2-Machine Engrave S/N 3-Debur
130 - (QC2- Inspect parts off machine FAI/FAIB)
140 - (QC8- Inspect parts - second check)
150 - (Outsource process-Anodize per QSI017 4.1.10.1) -Issue P/O to Groupe Altech : **043202** -ANODIZE
 COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required
160 - (Receive & Inspect for Damage & Mat'l Certs) Receive
170 - (QC6- All purchased or subcontracted products)
180 - (Identify as per dwg & Stock Location:) Identify and Stock
190 - (QC21- Final Inspection - Work Order Release)

Relu

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M7075T6S1.000X8.000	7075-T6 Sheet 1.000" X 8.000"	7.7700 ft (.777 ea)	100-Bandsaw - 1	5129 444

FM 138 097
5281 264

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M7075T6S1.000X8.000	8	27	0

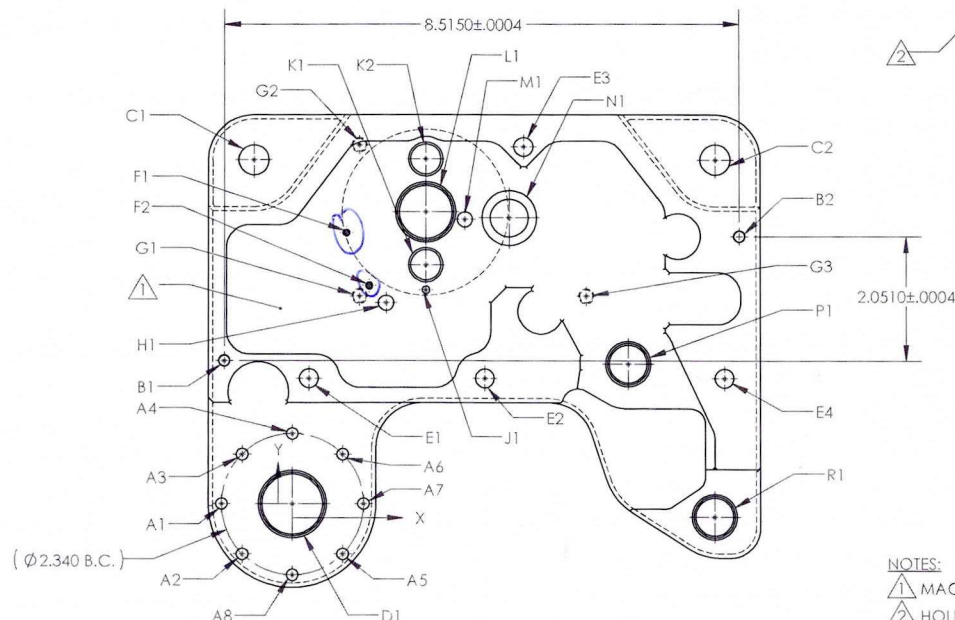
Part Specifications

Specifications could not be found.

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TAG	X LOC	Y LOC	SIZE
A1	-1.170	.000	10-32 UNF - 2B THRU ALL
A2	-.827	-.827	
A3	-.827	.827	
A4	.000	1.170	
A5	.827	-.827	
A6	.827	.827	
A7	1.170	.000	
A8	.000	-1.170	
B1	-1.125	2.379	$\phi .177$ THRU ALL $\sqcup \phi .1875^{+.0000}_{-.0005} \nabla .55$
B2			
C1	-.636	5.695	$\phi .500^{+.0005}_{-.000}$ THRU ALL
C2	6.989	5.695	
D1	.000	.000	$\phi 1.0000^{+.0005}_{-.0000}$ THRU ALL $\sqcup \phi 1.125 \nabla .520^{+.003}_{-.000}$
E1	.273	2.087	$\phi .3125^{+.0050}_{-.0000}$ THRU ALL
E2	3.177	2.087	
E3	3.818	5.913	
E4	7.142	2.087	
F1	.890	4.487	4-40 UNC - 2B $\nabla .712$
F2	1.264	3.613	
G1	1.105	3.445	
G2	1.105	5.945	
G3	4.855	3.445	$\phi .213 \nabla .375$ 1/4-28 UNF - 2B $\nabla .339$ FAR SIDE
H1	1.537	3.333	$\phi .250$ THRU ALL
J1	2.194	3.545	$\phi .129$ $\phi .125 \nabla .6$
K1	2.194	3.958	$\phi .500$ THRU ALL
K2	2.194	5.708	$\checkmark \phi .570 \times 82^\circ$
L1	2.194	4.833	$\phi .8754$ THRU ALL $\sqcup \phi .8751 \nabla .470^{+.003}_{-.000}$
M1	2.842	4.709	$\phi .2522$ $\phi .2513 \nabla .700$
N1	3.582	4.734	$\phi .625 \nabla .760$ $\sqcup \phi .9055 \nabla .720^{+.005}_{-.000}$
P1	5.550	2.326	$\phi .6250^{+.0005}_{-.0000}$ THRU ALL $\sqcup \phi .750 \nabla .470^{+.003}_{-.000}$
R1	6.977	-.213	$\phi .6250^{+.0005}_{-.0000}$ THRU ALL $\sqcup \phi .750 \nabla .540^{+.003}_{-.000}$

REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL APPROVED
8		A1 DRAWN BY CANAM.	9/12/2012	JAG
9		CHD HOLE TOLERANCES FOR B1 & B2, E1-E4, J1, K1 & K2, L1 AND N1 FOR BETTER FIT.	9/19/2012	JAG SE
10	14-0126	CHD TITLE BLOCK WAS RED BARN E DART. ADDED MACHINE ENGRAVE NOTE. CHD TOLERANCE ON NON-CRITICAL DIMENSIONS.	8/13/2014	DPD RW
11	15-0225	UPDATED HOLE TABLE WAS P2 IF R1. CHD M1 WAS $\phi .2505-.2508 \nabla .300$ IF $\phi .2513-.2522 \nabla .700$. CHD HOLE ∇ TO BE CALD FROM SAME SURFACE. D1 WAS $\phi .120^{+.003}_{-.0015} \nabla .520^{+.003}_{-.000}$. F1 & F2 WAS $\phi .3125 \nabla .712$. J1 WAS $\phi .25 \nabla .6$. L1 WAS $\phi .070^{+.003}_{-.000} \nabla .470^{+.003}_{-.000}$. H1 WAS $\phi .360 \nabla .760$. WAS $\phi .320^{+.005}_{-.000} \nabla .720^{+.005}_{-.000}$. P1 WAS $\phi .070^{+.003}_{-.000} \nabla .470^{+.003}_{-.000}$. R1 WAS $\phi .070^{+.003}_{-.000} \nabla .540^{+.003}_{-.000}$. ADDED HOLE ∇ NOTE. ADDED DIMS .170, .850. DELETED UNNECESSARY DIMS SHEET 2. CHD TOLERANCE ON NON-CRITICAL DIMENSIONS.	9/10/2015	DPD JAG
12	17-0114	UPDATED TO NEW STANDARDS. REMOVED DIM 7.390, 4.430. ADDED DIM 8.5150 $\pm$.0004, 8.5150 $\pm$.0004.	5/10/2017	SM JAG



NOTES:

- MACHINE ENGRAVE BATCH NUMBER.
- HOLE ∇ CALLED FROM THIS SURFACE.

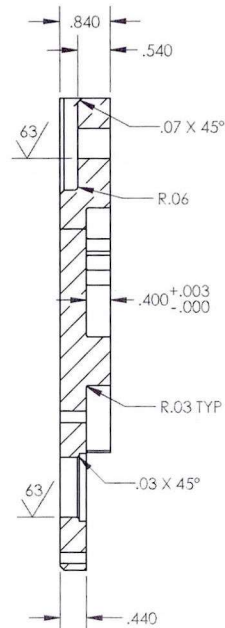
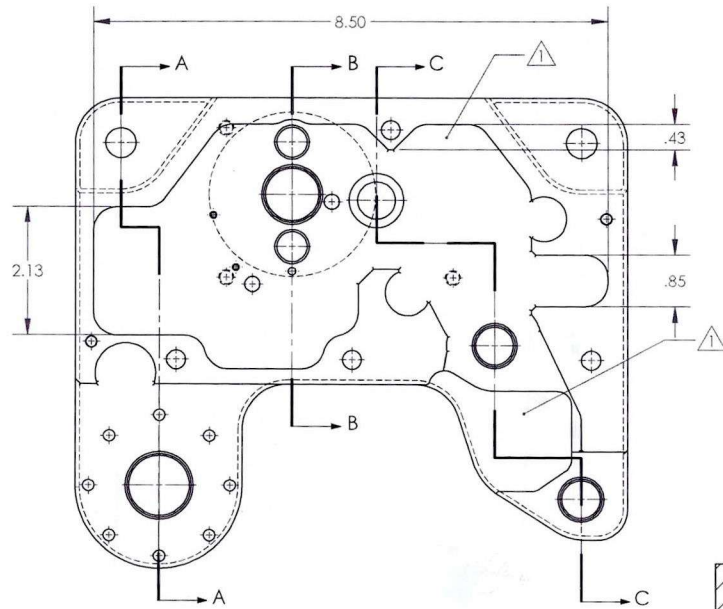


TITLE		SIDEPLATE - SOLENOID SIDE	
DWG NO.	C45-11-1	REV	12
MATL	7075-T6	UNLESS OTHERWISE SPECIFIED	
HEAT TREAT	BLACK ANODIZE	DIMENSIONS ARE IN INCHES	
SPEC	MIL-A-9625, TYPE II, CLASS II	FRACTIONS $\pm 1/8$	
DRAWN BY:	CANAM	DECIMALS $\pm .01$	
CHECKED:	RJC 05/10/2017	ANGLES $\pm 5^\circ$	
OPPS APPR:	AA 05/17/2017	SURFACES $\pm 125^\circ$	
QA APPR:	JL 05/24/2017	1. BREAK ALL SHARP EDGES	
APPROVED:	JAG 05/24/2017	2. DIMENSIONAL LIMITS APPLY	
SCALE	1:2	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DATE	4/10/2003	USED ON MODEL	
SHEET 1 OF 2			

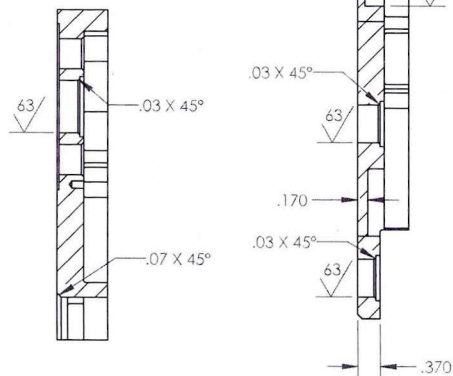
ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	S/O INFORMATION OR SPECIFICATIONS
			C45-11-1	1	SIDE PLATE SOLENOID	7075-T6	

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REV		ECR	DESCRIPTION	DATE	INITIAL	APPROVED
11	15-0225		ADDED DIMS .170, 8.50, DELETED UNNECESSARY DIMS.	9/10/2015	DPD	JAG

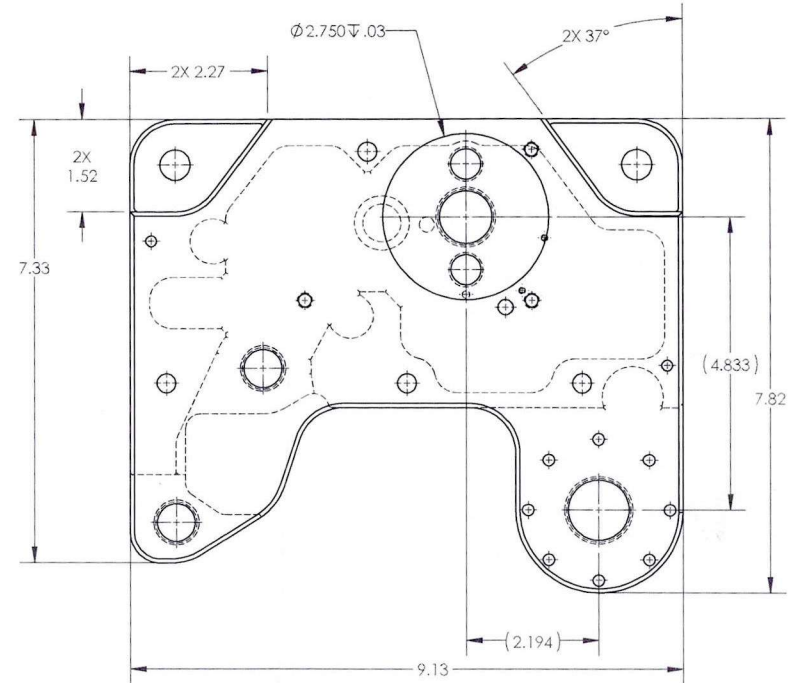


SECTION A-A



SECTION B-B

SECTION C-C



NOTE:

USE DXF PROFILE FOR POCKET DETAILS.

DART AEROSPACE	
TITLE SIDEPLATE - SOLENOID SIDE	
DWG NO. C45-11-1	REV 12
MAT'L 7075-T6 HEAT TREAT FINISH BLACK ANODIZE SPEC MIL-A-8625, TYPE II, CLASS II	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES ± 125/	
1. BREAK ALL SHARP EDGES .015 X 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009 USED ON MODEL	
DRAWN BY: CANAM CHECKED: RJC 05/10/2017 OPNS APPR: AA 05/17/2017 QA APPR: JL 05/24/2017 APPROVED: JAG 05/24/2017	
SCALE 1:2	DATE 4/10/2003
SHEET 2 OF 2	

DART AEROSPACE LTD		Work Order: 191.771
Description: side plate side		Part Number: C45-11-1
Inspection Dwg:	Rev: 12	Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
10-32	90/10 70	90	✓		90/10 70	
Ø.177	-.001/h.005	.177	✓		pin	
UØ.1875	-.0005/h.0000	.1875	✓		pin	
Ø.500	-.000/h.005	.500	✓		gage	
Ø.1000	-.0000/h.0005	1.0000	✓		gage/pin	
Ø.520	-.000/h.0003	.520	✓		dial gage	
Ø.3125	-.000/h.005	.3125	✓		pin	
4-40	90/10 90	90	✓		90/10 90	
1/4-28	90/10 90	90	✓		90/10 90	
Ø.250	-.001/h.005	.250	✓		pin	
Ø.125	-.000/h.0004	.125	✓		pin	
Ø.500	-.001/h.0006	.500	✓		pin	
Ø.570 92°	H-.005	.570	✓		pin	
Ø.8751	.8751/.8754	.8751	✓		gage/pin	
Ø.470	-.000/h.0003	.470	✓		dial gage	
Ø.2513	.2513/.2522	.2515	✓		pin	
Ø.700	H-.0005	.700	✓		PS 05	
Ø.625	-.0001/h.0005	.625	✓		PT 05	
UØ.905	.9050/h.9055	.9053	✓		gage/pin	
Ø.6250	-.000/h.0005	.6250	✓		gage/pin	
Ø.470	-.000/h.0003	.470	✓		dial gage	
Ø.540	-.000/h.0003	.540	✓		dial gage	
Ø.840	H-.005	.838/.844	✓		PT 01	ps warped
.400	-.000/h.0003	.4015	✓		dial gage	
.440	H-.005	.438/.445	✓		PT 01	ps warped
.540	H-.005	.543	✓		PT 01	
.370	H-.005	.371/.375	✓		PT 01	ps warped
.170	H-.005	.170	✓		PT 01	
7.33	H-.010	7.327	✓		PT 05	
.001 flatness	h.000/-0.010	.0010	✓		height gage	ps warped

Measured by: P.J. L.C.V.	Checked by: [Signature]	QC Inspector:
Date: 12-03-27	Date: 19/04/14	Date:

Engineering Approval: (if necessary)	Date:
--	--------------

Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO043202



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO043202
PO Date: 4/15/19
Due Date: 4/22/19
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:

Via: Ground
Pymt Terms: Net 60
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	191527	RBE350A93-3205-00E	Engine Gear Box Input Flange Holding Wrench -Issue P/O to ATG : PO -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant As Per Dwg RBE350A93- 3205-00E Rev. 2A	Firmed X8	-	4/22/19	8 pcs	0 pcs	8 pcs	\$15.00/pcs	\$120.00
2	191771	C45-11-1	Sideplate, Solenoid Side (Outsource process- Anodize per QSI017 4.1.10.1) -Issue P/O to Groupe Altech : -ANODIZE COLOR BLACK, PER IAW MIL-A- 8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed X10	-	4/22/19	10 pcs	0 pcs	10 pcs	\$6.75/pcs	\$67.50



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO043202



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	191775	C45-2-1	Sideplate - MRK Outsource process- Anodize per QSI017 4.1.10.1) -Issue P/O to ATG: -ANODIZE COLOR BLACK, PER IAW MIL-A- 8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed	-	4/22/19	11 pcs	0 pcs	11 pcs	\$6.75/pcs	\$74.25
Grand Total:											\$261.75

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 4/16/19 9:25 AM dart.Lussier.Patrick



Certificat de Conformité / Certificate of Compliance

(018516-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

018516 - 1

Livré à / Ship to

DART AEROSPACE LTD

1270 ABERDEEN STREET

HAWKESBURY, ON, K6A1K7

CANADA

Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD

1270 ABERDEEN STREET

HAWKESBURY, ON, K6A1K7

CANADA

BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
18-Apr-2019		SPARTAKOS BOUNTOURIS		PO043202				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBE350A93-3205-00E Rev.	RBE350A93-3205-00E ANODIZE RED PER IAW MIL-A-8625F TYPE 2 CLASS 2 WATER SEALANT	ANODIZE CH	8	8	0	0	0
2	C45-11-1 Rev.	C45-11-1 01-ANO-BLACK [ANODIZE BLACK] MIL-A-8625F TYPE 2 CLASS 2	ANODIZE CH	10	10	0	0	0
3	C45-2-1 Rev.	C45-2-1 01-ANO-BLACK [ANODIZE BLACK] MIL-A-8625F TYPE 2 CLASS 2	ANODIZE CH	11	11	0	0	0

Notes Additionnelles / Additional Notes

3 boîtes

Epaisseur réelle
Actual Thickness
Inspecteur Qualité
Quality Inspector
Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.